



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D2574
Job Sheet 200384



Part No: D2574

Job Qty: 10 pcs

Part Name: Saddle, Aft, In



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 9/10/19

Job Tracking No:

Due Date: 10/8/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV F IPP Rev: I As Per RevE 06-01-27 JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Machining - Issue SN	10 pcs	10/8/19		0.00	0.00	HAAS - 1		SBL 19/10/28
							HAAS - 2		
							HAAS - 3		
							HAAS - 4		
100	HAAS 4 Axis - B4B	10 pcs	10/8/19		1.00	16.13	HAAS - 1 - B4B		SBL 19/11/16
							HAAS - 2 - B4B		
							HAAS - 3 - B4B		
							HAAS - 4 - B4B		
110	Conventional Mill - 1 - B4B	10 pcs	10/8/19		0.00	1.25	Conventional Mill - 1 - B4B		SBL 19/11/16
							Conventional Mill - 2 - B4B		
120	QC 2	10 pcs	10/8/19		0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		



Container No: S226870



Part: D2574

Job No: 200384

Serial No/Batch: S226870

Revision: Rev.F

Inspector:

Exp Date:

Instructions: Various STC's

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL : 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 10/26/19

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				B4B		
				Handfinish - 1 - 16 - B4B		
				Handfinish - 1 - 17 - B4B		
				Handfinish - 1 - 18 - B4B		
				Handfinish - 1 - 19 - B4B		
				Handfinish - 1 - 20 - B4B		
				Handfinish - 1 - 21 - B4B		
				Handfinish - 1 - 22 - B4B		
150	Powdercoat - 1 White GI(A)- B4B	10 pcs	10/8/19	0.00	0.33	Powdercoat - 1 - B4B
				Powdercoat - 2 - B4B		
				Powdercoat - 3 - B4B		
				Powdercoat - 4 - B4B		
160	QC 3	10 pcs	10/8/19	0.00	0.00	QC 3 - 10
				QC 3 - 13		
				QC 3 - 15		
				QC 3 - 17		
				QC 3 - 18		
				QC 3 - 2		
				QC 3 - 28		
				QC 3 - 3		
				QC 3 - 30		
				QC 3 - 34		
				QC 3 - 36		
				QC 3 - 41		
				QC 3 - 51		
				QC 3 - 58		
				QC 3 - 59		
				QC 3 - 68		
				QC 3 - 9		
				QC 3 - 40		
				QC 3 - 19		
				QC 3 - 43		
				QC 3 - 24		
				QC 3 - 61		
				QC 3 - 81		
170	Packaging 3-1 - Stock - B4B	10 pcs	10/8/19	0.00	0.00	Packaging 3 - 1 - B4B
				Packaging 3 - 2 - B4B		
				Packaging 3 - 3 - B4B		
				Packaging 3 - 4 - B4B		
				Packaging 3 - 5 - B4B		
				Packaging 3 - 6 - B4B		
				Packaging 3 - 7 - B4B		
				Packaging 3 - 8 - B4B		
				Packaging 3 - 9 - B4B		
				Packaging 3 - 10 - B4B		
				Packaging 3 - 11 - B4B		
				Packaging 3 - 12 - B4B		
				Packaging 3 - 13 - B4B		
				Packaging 3 - 14 - B4B		
				Packaging 3 - 15 - B4B		
				Packaging 3 - 16 - B4B		
				Packaging 3 - 17 - B4B		
				Packaging 3 - 18 - B4B		

				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
180 QC 21 - SA	10 pcs	10/8/19	0.00 0.00	QC 21 - SA - 21	
				QC 21 - SA - 70	DAS
				QC 21 - SA - 53	21

NOV 20 2019

Part Op 100 - (HAAS CNC vertical machine #1) Program Batch No. 521687 Machine Step No 1 per Folio FA051 and inspect
 Descriptions: per attached Dimension Sheets 2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets
 110 - (Manufacture as per dwg) Machine keyway as per dwg D2573 & D2574
 120 - (QC2- Inspect parts off machine FAI/FAIB)
 130 - (QC8- Inspect parts - second check)
 140 - (Chemical Conversion Coat per QSI005 4.1)
 150 - (White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum) START TIME: _____ FINISH TIME: _____
 160 - (QC3- Inspect Part Finish)
 170 - (Identify as per dwg & Stock Location: _____)
 180 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D6101-005	Saddle Billet	10 pcs (1 ea)	90-Machining - Issue SN	3196167

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Machining - Issue SN	D6101-005	10	66	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Saddle, Aft Inboard	0.438Inches	+ 0.005 - 0.000	0.443 0.438	
2	Saddle, Aft Inboard	1.745Inches	+ 0.010 - 0.000	1.755 1.745	
3	Saddle, Aft Inboard	3.495Inches	+ 0.010 - 0.000	3.505 3.495	
4	Saddle, Aft Inboard	1.745Inches	+ 0.010 - 0.000	1.755 1.745	
5	Saddle, Aft Inboard	7.990Inches	+ 0.020 - 0.000	8.010 7.990	
6	Saddle, Aft Inboard	0.490Inches	+ 0.020 - 0.000	0.510 0.490	
7	Saddle, Aft Inboard	0.257Inches	+ 0.005 - 0.000	0.262 0.257	
8	Saddle, Aft Inboard	0.375Inches	+ 0.005 - 0.000	0.380 0.375	
9	Saddle, Aft Inboard	0.490Inches	+ 0.020 - 0.000	0.510 0.490	
10	Saddle, Aft Inboard	1.174Inches	+ 0.010	1.184	

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			- 0.000	1.174
11	Saddle, Aft Inboard	0.558Inches	+ 0.020 - 0.000	0.578 0.558
12	Saddle, Aft Inboard	1.174Inches	+ 0.010 - 0.000	1.184 1.174
13	Saddle, Aft Inboard	1.365Inches	+ 0.010 - 0.000	1.375 1.365
14	Saddle, Aft Inboard	2.495Inches	+ 0.010 - 0.000	2.505 2.495
15	Saddle, Aft Inboard	4.119Inches	+ 0.010 - 0.000	4.129 4.119
16	Saddle, Aft Inboard	0.115Inches	+ 0.020 - 0.000	0.135 0.115
17	Saddle, Aft Inboard	0.115Inches	+ 0.020 - 0.000	0.135 0.115
18	Saddle, Aft Inboard	0.240Inches	+ 0.020 - 0.000	0.260 0.240
19	Saddle, Aft Inboard	0.115Inches	+ 0.020 - 0.000	0.135 0.115
20	Saddle, Aft Inboard	0.178Inches	+ 0.020 - 0.000	0.198 0.178
21	Saddle, Aft Inboard	3.210Inches	+ 0.040 - 0.000	3.250 3.210
22	Saddle, Aft Inboard	0.230Inches	+ 0.020 - 0.000	0.250 0.230
23	Saddle, Aft Inboard	0.115Inches	+ 0.020 - 0.000	0.135 0.115
24	Saddle, Aft Inboard	0.307Inches	+ 0.005 - 0.000	0.312 0.307
25	Saddle, Aft Inboard	0.760Inches	+ 0.005 - 0.000	0.765 0.760
26	Saddle, Aft Inboard	0.352Inches	+ 0.020 - 0.000	0.372 0.352
27	Saddle, Aft Inboard	0.470Inches	+ 0.060 - 0.000	0.530 0.470
28	Saddle, Aft Inboard	0.615Inches	+ 0.020 - 0.000	0.635 0.615
29	Saddle, Aft Inboard	0.053Inches	+ 0.020 - 0.000	0.073 0.053
30	Saddle, Aft Inboard	0.240Inches	+ 0.020 - 0.000	0.260 0.240
31	Saddle, Aft Inboard	1.500Inches	+ 0.020 - 0.000	1.520 1.500
32	Saddle, Aft Inboard	0.115Inches	+ 0.020 - 0.000	0.135 0.115
33	Saddle, Aft Inboard	0.240Inches	+ 0.040 - 0.000	0.280 0.240
34	Saddle, Aft Inboard	0.240Inches	+ 0.020 - 0.000	0.260 0.240
35	Saddle, Aft Inboard	2.000Inches	+ 0.020 - 0.000	2.020 2.000
36	Saddle, Aft Inboard	0.023Inches	+ 0.020 - 0.000	0.043 0.023

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DART AEROSPACE LTD	Work Order: 200384
Description: Saddle, Aft Inboard	Part Number: D2574
Inspection Dwg: D2574 Rev. F	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2574 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443		0.438	0.438	0.438	0.438		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.000	7.997	7.998	7.998		
F	0.490	0.510		0.497	0.501	0.499	0.497		
G	0.257	0.262		0.258	0.258	0.258	0.258		
H	0.375	0.380		0.375	0.375	0.375	0.375		
I	0.490	0.510		0.499	0.4885	0.4995	0.500		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		0.567	0.565	0.570	0.5665		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.365	1.375		1.370	1.370	1.370	1.370		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	4.119	4.129		4.124	4.124	4.124	4.124		
P	0.115	0.135		0.130	0.135	0.135	0.135		
Q	0.115	0.135		0.125	0.126	0.126	0.126		
R	0.240	0.260		0.250	0.250	0.252	0.251		
S	0.115	0.135		0.128	0.135	0.132	0.132		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	3.210	3.250		3.231	3.231	3.231	3.231		
V	0.230	0.250		0.241	0.249	0.246	0.248		
W	0.115	0.135		0.132	0.134	0.126	0.123		
X	0.307	0.312		0.312	0.312	0.312	0.312		
Y	0.760	0.765		0.760	0.760	0.760	0.760		
Z	0.352	0.372		0.368	0.365	0.368	0.368		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.622	0.623	0.622	0.622		
AC	0.053	0.073		0.065	0.060	0.060	0.060		
AD	0.240	0.260		0.250	0.258	0.255	0.256		
AE	1.500	1.520		1.510	1.510	1.510	1.510		
AF	0.115	0.135		0.135	0.135	0.135	0.135		
AG	0.240	0.280		0.260	0.260	0.260	0.260		
AH	0.240	0.260		0.252	0.252	0.254	0.254		
AI	2.000	2.020		2.000	2.000	2.000	2.000		
AJ	0.023	0.043		0.040	0.040	0.035	0.035		

Accept/Reject

Measured by: SBL	Date: 14/11/01
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Audited by: [Signature]	Date: 19/11/02
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Rev	Date	Change	Revised by	Approved
B	02.09.27	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	
F	13.03.07	Dwg Rev updated	KJ	

DART AEROSPACE LTD	Work Order: 200384
Description: Saddle, Aft Inboard	Part Number: D2574
Inspection Dwg: D2574 Rev. F	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2574 Rev. E and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	#5	#6	#7	#8		
A	0.438	0.443		438	438	438	438		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		7.999	7.998	7.998	7.998		
F	0.490	0.510		497	497	497	498		
G	0.257	0.262		0.258	0.258	0.258	0.258		
H	0.375	0.380		0.375	0.375	0.375	0.375		
I	0.490	0.510		499	499	499	499		
J	1.174	1.184		1.180	1.178	1.179	1.179		
K	0.558	0.578		566	567	567	568		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.365	1.375		1.370	1.370	1.370	1.370		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	4.119	4.129		4.124	4.124	4.124	4.124		
P	0.115	0.135		135	135	138	133		
Q	0.115	0.135		0.126	0.126	0.125	0.126		
R	0.240	0.260		0.252	0.252	0.250	0.251		
S	0.115	0.135		130	132	129	130		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	3.210	3.250		3.230	3.230	3.230	3.230		
V	0.230	0.250		245	246	242	243		
W	0.115	0.135		125	127	126	125		
X	0.307	0.312		312	312	311	312		
Y	0.760	0.765		0.760	0.760	0.760	0.760		
Z	0.352	0.372		368	368	368	368		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		622	621	622	622		
AC	0.053	0.073		0.063	0.058	0.062	0.062		
AD	0.240	0.260		254	255	250	250		
AE	1.500	1.520		1.510	1.510	1.510	1.510		
AF	0.115	0.135		135	135	0.135	135		
AG	0.240	0.280		0.260	0.260	0.260	0.260		
AH	0.240	0.260		253	254	252	252		
AI	2.000	2.020		2.000	2.000	2.000	2.000		
AJ	0.023	0.043		0.035	0.035	0.035	0.035		

Accept/Reject

Measured by: SBL	Audited by: [Signature]
Date: 14/01/01	Date: 17/11/09

Rev	Date	Change	Revised by	Approved
B	02.09.27	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	
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DART AEROSPACE LTD		Work Order: 200384
Description: Saddle, Aft Inboard		Part Number: D2574
Inspection Dwg: D2574 Rev. F		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2574 Rev. E and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	9	10	X	X		
A	0.438	0.443		.438	.438				
B	1.745	1.755		1.750	1.750				
C	3.495	3.505		3.500	3.500				
D	1.745	1.755		1.750	1.750				
E	7.990	8.010		7.998	7.998				
F	0.490	0.510		.497	.499				
G	0.257	0.262		.257	.257				
H	0.375	0.380		.375	.375				
I	0.490	0.510		.498	.500				
J	1.174	1.184		1.179	1.179				
K	0.558	0.578		.566	.567				
L	1.174	1.184		1.179	1.179				
M	1.365	1.375		1.370	1.370				
N	2.495	2.505		2.500	2.500				
O	4.119	4.129		4.124	4.124				
P	0.115	0.135		.135	.13				
Q	0.115	0.135		.125	.125				
R	0.240	0.260		.250	.250				
S	0.115	0.135		.124	.130				
T	0.178	0.198		.188	.188				
U	3.210	3.250		3.230	3.230				
V	0.230	0.250		.243	.243				
W	0.115	0.135		.125	.126				
X	0.307	0.312		.312	.312				
Y	0.760	0.765		.760	.760				
Z	0.352	0.372		.368	.368				
AA	0.470	0.530		.500	.500				
AB	0.615	0.635		.622	.622				
AC	0.053	0.073		.063	.063				
AD	0.240	0.260		.251	.252				
AE	1.500	1.520		1.510	1.510				
AF	0.115	0.135		.135	.135				
AG	0.240	0.280		.260	.260				
AH	0.240	0.260		.252	.252				
AI	2.000	2.020		2.000	2.000				
AJ	0.023	0.043		.035	.035				
Accept/Reject									

Measured by: SBL
Date: 19/11/01

Audited by: [Signature]
Date: 19/11/02

Rev	Date	Change	Revised by	Approved
B	02.09.27	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	
F	13.03.07	Dwg Rev updated	KJ	



Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

Route update only

NCR No. _____

Job: _____

Part No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐

DEPARTMENT/PROCESS

Skid-tube ☐
Machining ☐
Large Fab ☐

Cross tube ☐
Small Fab ☐
Finishing ☐

Eng. (Non-AW) ☐
Prod. Eng. Coord. ☐
Rec/Store/Packaging ☐

Engineering ☐
Water Jet ☐
Supplier ☐
Quality ☐

Date: _____ Sequence #: _____

QTY Affected: _____

MRB (QS1042)

Description Work Order Deviation

Disposition

Completed By _____

Lead hand / Supervisor _____

QC / QA Coordinator _____

Root Cause

Operator ☐
Manufacturing Process ☐
Equip/Tooling ☐
Handling/Preservation ☐
Material ☐
Product Improvement ☐
Process Improvement ☐
Human Factors ☐

FAULT CATEGORY

☐	Pressure/Forced	☐	Contamination	☐	Power Loss/Surge	☐	Positioned Wrong
☐	Bending	☐	Misaligned/off center	☐	Folio/Program	☐	Outside Tolerance
☐	Crushing	☐	BOM/Route	☐	Grain Direction	☐	Drawing
☐	Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Finish
☐	Crimp/Kink/Ripple/Wave/Twist	☐	Incomplete/Unclear Instructions	☐	Wrong Stock Pulled	☐	Part Lost/Missing
☐	Marks/Chatter	☐	Drill Holes	☐	Out of Sequence	☐	Misread
☐	Mislabeled	☐	Fit/Function	☐	Off-set/Set-up	☐	

Other/Details: _____